

Work Order ID 151496

Tuesday, September 27, 2016 11:54:38 AM

151496

Page 1

Item ID: D3167-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw
 Start Date: 9/13/2016 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 9/27/2016 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: **SEP 28 2016** Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3167	Rev A1								

120 FLOW WATER JET 0.00
120 Waterjet Memo 0.27 4 16/10/05
 FLOW CNC Waterjet Cut Blank as per File D3167-1_BLANK

130 HAAS CNC VERTICAL MACHINING #1 0.00
130 HAAS 1 Memo 0.45 4 Ø **DAS 49 9-89**
 HAAS CNC vertical machine #1 Note: (2) Bearpaw for (1) Kit 16/10/23
 1-Inspect material for defects or damage prior to machining
 2-Machine as per Folio FA285 and Dwg D3167
 3-Deburr

140 QC2- Inspect parts off machine FAI/FAIB 0.00
140 QC Memo 0.01 4 Ø **DAS 49 9-89**
 Quality Control 16/10/24

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	Design ☐	Doc/Data ☐	Equip/Tooling ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Handling/Pre ☐	Material ☐	Internal Transport ☐	Tribal Knowledge ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
LOA ☐	Substation ☐	Past Expiry Date ☐	Misidentified ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
				Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
				Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
				Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
				Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
				Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
				Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
				Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐				OTHER : _____			

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC8- Inspect parts - second check	0.00							DAS 33 9-89
150						4	2		
QC	Memo	0.01							16/10/25
Quality Control									
151	Identify as per dwg & Stock Location: <u>St</u>	0.00							DAS 8 9-89
151						4			
Packaging	Memo	0.01						OCT 2 5 2016	
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
190									16/10/26
QC	Memo	0.07							
Quality Control									DAS 21 9-89 OCT 2 5 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Misidentified ☐	Past Due ☐																																																														

Picklist Print

Tuesday, September 27, 2016 11:54:37 AM

Page 1

Work Order ID: 151496

151496

Parent Item: D3167-1

D3167-1

Parent Item Name: Bearpaw

Start Date: 9/13/2016

Required Date: 9/27/2016

Start Qty: 4.00

Required Qty: 4.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased		No		120	sf	226.0000	3.6	14.4			

MUHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

ac 16/10/05

Location

Loc Qty

Loc Code

MAT

212

m135497

212

MAT018

14

m135013

14

15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

DART AEROSPACE LTD		Work Order: 151496
Description: Bearpaw		Part Number: D3167-1
Inspection Dwg: D3167 Rev: A1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**

 ☐ **Prototype**

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.06 x 45°	+0.030/-0.010	0.060x45°	/		vern	
B	5.80	+/-0.030	5.795	/		"	
C	0.25 x 45°	+/-0.030	0.256x45°	/		"	
D	R0.25	+/-0.030	0.250	/		AG	
E	0.200	+/-0.030	0.185	/		vern	mark-5
F	0.250	+/-0.010	0.257	/		vern	mark-5
G	0.625	+/-0.030	0.640	/		"	
H	0.375	+/-0.010	0.384	/		"	
I	0.950	+0.030/-0.010	0.960	/		"	
J	3.21	+/-0.030	3.215	/		"	
K	19.00	+/-0.030	19.00	/		Tape	
L	Ø0.260	+0.005/-0.000	0.260	/		vern	mark-5
M	Ø0.93	+/-0.030	0.930	/		"	
N	0.30	+0.030/-0.000	0.310	/		"	
O	0.375	+/-0.030	0.376	/		"	
P	7.23	+/-0.030	7.23	/		"	
Q	4.54	+/-0.010	4.543	/		"	
R	2.00	+/-0.030	2.016	/		"	
S	12.000	+/-0.010	11.999	/		vern 12"	CNC-02
T	6.000	+/-0.010	6.000	/		vern	mark-5
U	23.75	+/-0.030	23.75	/		Tape	

Measured by: DAS 49 9-89	Audited by: DAS 33 9-89 16/10/23	Prototype Approval:	N/A
Date: 16/10/23	Date: 16/10/23	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D130-700-011	KJ/RF	

DART

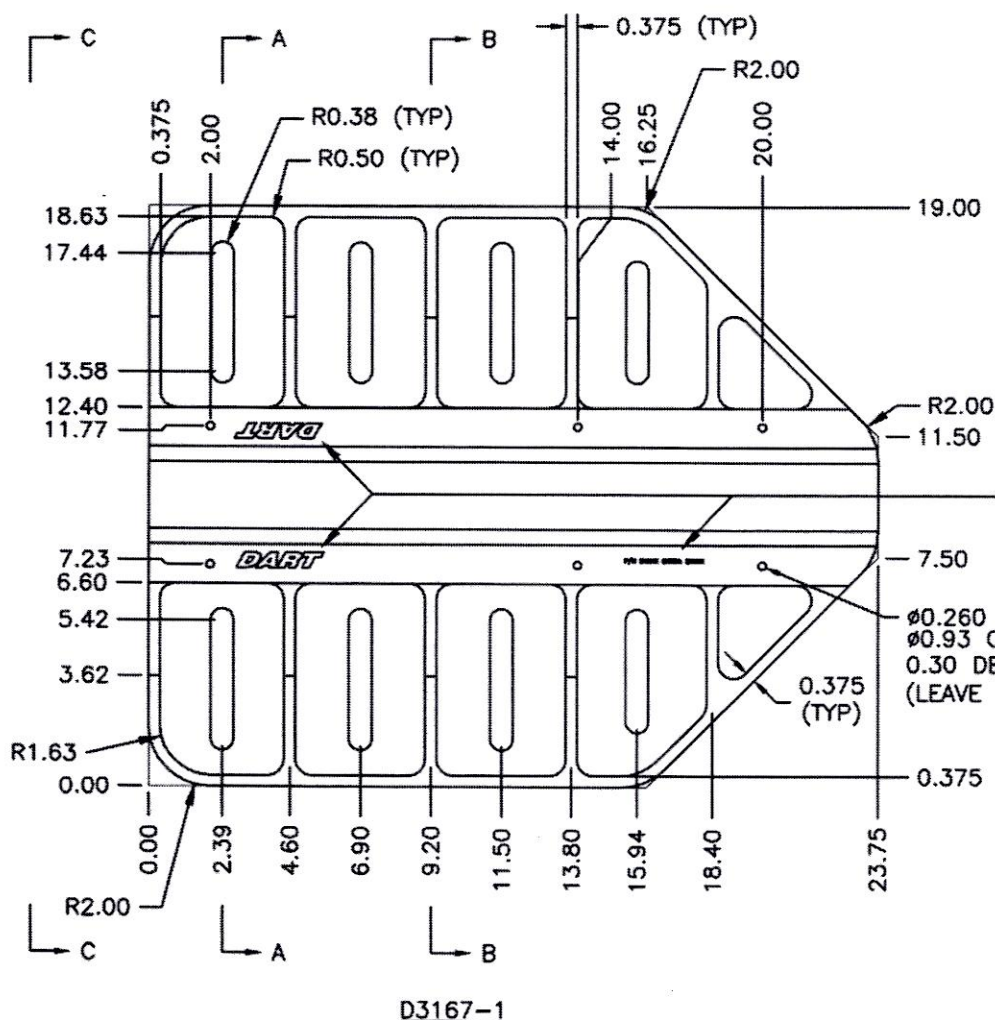


DESIGN		DRAWN BY		DART AEROSPACE LTD	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	HANESBURY, ONTARIO, CANADA	REV. A
DATE	02.10.08	TITLE	BEARPAW	SHEET 1 OF 2	SCALE
A	02.10.08	NEW ISSUE			1:6
A1	02.12.17	5.80 WAS 5.50			

RELEASED
02.10.25

ENGRAVE LOGO TO MAX
DEPTH OF 0.012. ENGRAVE
PART AND BATCH NUMBERS
TO MAX DEPTH OF 0.010.
(TYPICAL LOCATION AS
ILLUSTRATED)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151496 MLC
16-09-28

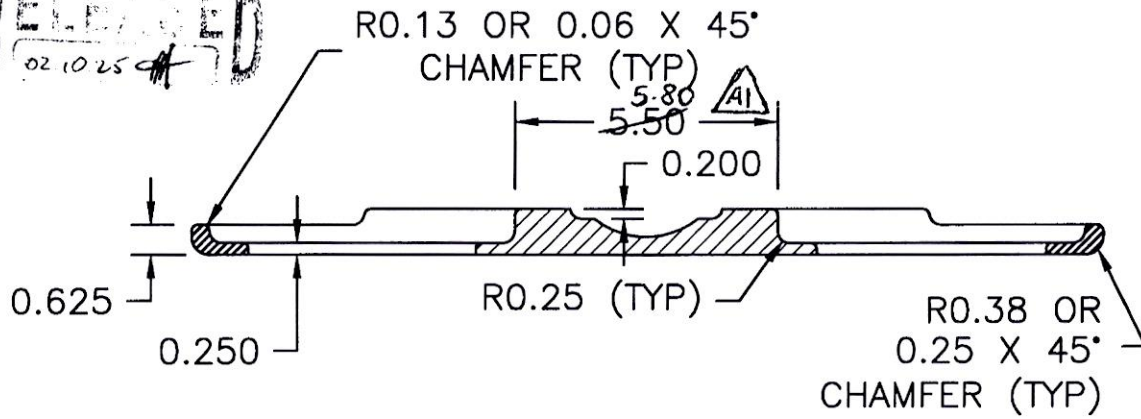


MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

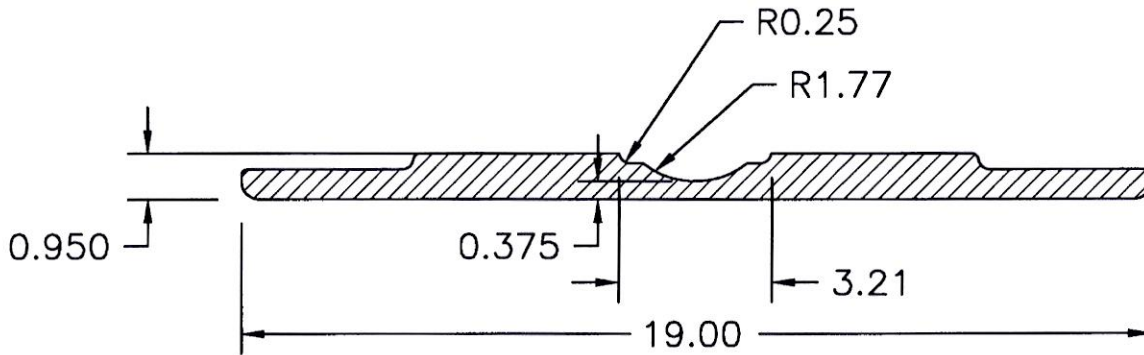


DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3167	REV. A SHEET 2 OF 2
DATE 02.10.08		TITLE BEARPAW	SCALE 1:4

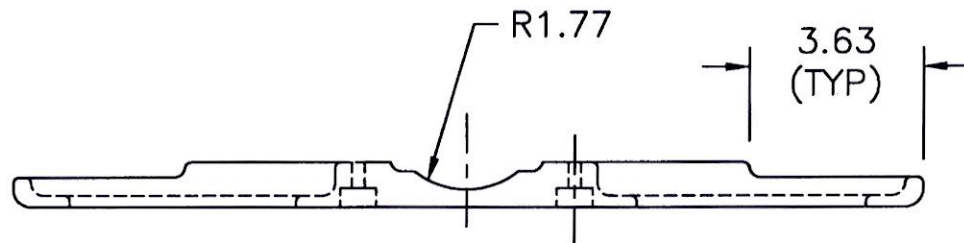
RELEASED
02.10.25



SECTION A-A



SECTION B-B



SECTION C-C

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